Work Order ID 113173							
Work Order ID 113173 February-12-14 8:48:39 AM	*113	3173*					Page 1
Item ID: D3414-041		*N90002 Cust Item ID: Customer:	10100) * 8	Setup Star Sto	1/1	S1* S2*
Approvals: Process Plan: MUS Date: W-02-14 QC: Date:	Tooling: SPC (Y/N):	Date:		F	Run Star Sto	^IVI	R1*
Sequence ID/ Operation Work Center ID Description Draw Nbr Revision Nbr	Set Up/ Run Hours	Tool ID To	ol# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nor Revision Nor D3414 Rev C							
*100 *100 *100 *100 Memo FLOW CNC Waterjet Memo 1-Cut as per Dwg D3414-1 Dwg Rev: Prog Rev: 2-Deburr if necessary	0.00			24	0	. v	Jn14-03-1
OC2- Inspect parts off machine FAI/FAIB *110* QC Memo Quality Control	0.00			24	0	d (c	Jm 14-03-

DQA:		122	Date:										TOADT
				o korá	1817	WORK ORDER NON	I-CO	NFO	RMANCE /	UPDATE			DARI
QA Closed:	14		Date:		lie :						ork Order up	date only	
Work Orde	er:					DISPOSITION		1,5		AGAINST DI	PARTMENT	/PROCESS	
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raite	١٠.	1225			(M/	Use-as-is	1		noforming	Finishing	-	d. Eng. Coor re/Packaging	Quality Other
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Root					Desc	ription of work order update	In	itial	А	Action	Sign &		
Cause		Date	Step	Qty	46	or non-conformance	Chi	ef Eng	Des	scription	Date	Verification	QC Inspector
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опарргочеи	501			1-010			FAU	LT CAT	TEGORY		S North Comments		1
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The second		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	i i	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		nspect	ion Incomplete/	'Unqualified	Part Lost/Mi	ssing	Weld
	-	Cuffs			横尾	Contamination		nstruct	tions Incomplete	e/Unclear	Part Moved		Wrong Stock Pulled
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		Heat Trea	it		e ji	Cut Too Short		Mislabe	eled	R. C.	Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d	15.0±1	(V		
		Marks/Ch	atter		0.	Drill Holes		Off-set					
		Turning S				Finish		Out of (Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence		01		

Work Ord February-12-14	er ID 113173 8:48:39 AM		*113	173*			Page 2
Item ID: Revision ID: Item Name:	D3414-041 Lug		Accept	*N900040	100* s	Ct	*NS1* *NS2*
Start Date: Required Date: Reference:	2/10/14 Start Qty: 24. 2/10/14 Req'd Qty: 24.			Cust Item ID: Customer:			
Approvals:	Process Plan:	Date:	Tooling:	Date:	R	tun Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/ Work Center II 120 *1 20*	D Operation Description QC8- Inspect parts	- second check	Set Up/ RunHours 0.00 27 9-59	Tool ID Tool #	Plan Accept Code Qty		ject Insp.
Quality Control	NCIII)		0.00		Cours		14636
120 Brake NC Brake NC	Memo 1-Debu 2-Form		0.00	DAS 30 9-89	24		
140 *140* Large Fab	Memo		0.00		19		14-03-05 Be
Large Fab	1- Web A/R S	d using location Jig DT9625 as S.S. welding rod Batch:	Der Dwg D3414				100

4 F W

DQA:		Date:		. 5-1									DART
					WORK ORDER NON	-CC	ONFO	RMANCE / I	UPDATE				AEROSPACE
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Work Order:					DISPOSITION				AGAINST	DEP	ARTMENT	PROCESS	
		5.81			Rework	1		Skid-tube	Crosstube			Water Jet	Engineering
Part No.				1	Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	moforming	Finishing		Rec/Stor	re/Packaging	Other
NCR No.	1191				Suspected Unapproved			Large Fab	Composite			Supplier	
				100	Marie Committee					_			
Root	0-1-	C4	0.	Descr	ription of work order update		nitial	1000	ction		Sign &	V 16 1	001
Cause	Date	Step	Qty	34 5	or non-conformance	Ch	ief Eng	Des	cription	-	Date	Verification	QC Inspector
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Landing	1				General		1 7.				2 20 10 7220		7
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	Crushing				Countersink	\vdash		gned/off center			ositioned V		Wrong Stock Fulled
	Heat Trea	at		0.5	Cut Too Short		Mislab		o. K -		ower Loss/		Other
1 The state of the	Inspectio		Tube		Drawing		Misrea		: - :7); =	ш ^г	OWE! 1033/		y San
	Marks/Ch				Drill Holes		Off-set			-			
1	Turning S			9818	Finish			Calibration		-			
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February-12-1	4 8:48:39 AM	fi .		1							
Item ID: Revision ID: Item Name:	D3414-041 Lug			Accept	*N900	040	100	ገ*	Setup St St	171	S1* S2*
Start Date: Required Date Reference:	2/10/14 e: 2/10/14	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item l Customer:	ID:					
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:]		art *N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			St	ор * М	R2*
Sequence ID/ Work Center 150 *150* QC Quality Control	ID	Operation Description QC9- Inspect visual per Q Memo QC5- Inspect part complete Memo		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty (4-0)	Reject Number	DAS 9 9-89
170 Fowdercoat Powder Coating		White Gloss(Ref.4.3.5.1) M/DS C Memo START TIMI OVEN TEMI FINISH TIMI	97. E: 1:30 PERATURE: 400	0.00				19	Ø /	4-3-1	H 88

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						WORK ORDER NON	-CO	ONFORM.	ANCE /	UPDATE			AEROSPACE
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Work Order	r.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
是 樹		OF PERSONS				Rework		Skic	l-tube	Crosstube		Water Jet	Engineering
Part No	0	Lauri II		B	all t	Scrap		manufacture and the second	hining	Small Fab		d. Eng. Coor.	Quality
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Cause	L	ate Ste	2 1	Qty		or non-conformance	CI	ner eng	Des	scription	Date	verification	QC Inspector
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海をま	Cri	cks np/Kink/Rip	nle/V	Mayro		Burrs	-	Hardware	ncomplete	'Unqualified	Part Lost/Mi	-	Temperature/Cure Weld
	Cuf	LONG CO.	pie/ v	vave		Contamination	-	Instructions		200	Part Moved	331118	Wrong Stock Pulled
1		shing				Countersink	-	Misaligned			Positioned V	Vreng	
		t Treat				Cut Too Short		Mislabeled	,		Power Loss/		Other
i io	-	pection Strip	in Tu	ube		Drawing		Misread					
The state of the s		rks/Chatter			19	Drill Holes		Off-set					
		ning Sequer	ce			Finish		Out of Calib	ration				
	Wa	ve/Twist in	Tube			Fit/Function		Out of Sequ	ence				

Work Orde February-12-14				*113	173*							Page 4	
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3414-041 Lug 2/10/14 2/10/14	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*	Accept	*N900 Cust Item I Customer:		100)*	Setup :	Start Stop	IV	S1* S2*	
Approvals:	Process Pla	in:	Date:	Tooling:	Da	nte:			Run 5	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):		ite:			9	Stop	*N	R2*	
Sequence ID/ Work Center II 180 *1 2 \(\text{*1} \) QC Quality Control 190 *1 \(\text{*1} \) Packaging Packaging		Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stoo	ck Location:	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty	BAC	Reject Number	Insp. Stamp 03 15	
*200 *200* QC Quality Control		QC21- Final Inspection - \ Memo	Work Order Release	0.00						U	L03-	17	
2000				唯作詞			(#	74:	03	3-17		

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DQA:	ik fi	Date:										TART
					WORK ORDER NON	-CC	ONFO	RMANCE / L	JPDATE			AERDSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Order:					DISPOSITION			= 1	AGAINST DE	PARTMENT	/PROCESS	We want
Part No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance		nitial ief Eng		ction cription	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
- WH (4)	- INCHE					FAI	ULT CA	TEGORY	f			Viii-
Landing	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea	k/Ripple			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Grain Hardwa Inspect Instruct	tion Incomplete/U tions Incomplete, gned/off center	/Unclear	Outside Dim Over/Under Part Incorrect Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Inspection Marks/Ch	atter			Drawing Drill Holes	d	Misrea Off-set	d		-		
	Turning Se Wave/Tw			Sel 16.3	Finish Fit/Function	-	1	Calibration				

Loc Oty

48

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Loc Code

Location

WA001

106695

111462

DQA:	Aug.	_ Date:										DART
					WORK ORDER NON	-CC	ONFO	RMANCE / U	JPDATE			AEROSPACE
QA Closed:		Date:		M. Fran	47 J. W.				Wo	ork Order up	date only	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
全全人					Rework	1		Skid-tube	Crosstube	ĺ	Water Jet	Engineering
Part No.	- 16				Scrap			Machining	Small Fab	Proc	d. Eng. Coor.	Quality
					Use-as-is		Therr	moforming	Finishing	Rec/Stor	e/Packaging	Other
NCR No.					Suspected Unapproved]	- 4	Large Fab	Composite		Supplier	
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Doc/Data								1 . 1 . 1 . L				
Equip/Tooling			166					1 14 14 14 15				, <u>1</u> ,23
Handling/Pre								45				1 4
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Operator		150										1 1
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Supplier		1 5 3		20				330				36
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Landing					General		1			1		7
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	Cracks	ink/Pinst-	AMour		Broken/Damage/Defect	-	Hardwa		Inqualified	Part Incorred Part Lost/Mi		Temperature/Cure Weld
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	_	wist in Tul			Fit/Function		-	Sequence	W.			

DART AEROSPACE LTD	Work Order:	113173
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	0.314	-			Inna
1.19	+/-0.030	1.197	-		2)\
1.00	+/-0.030	1.005				λ
3.38	+/-0.030	3.381			N	Y.
5.350	+/-0.010	5.353				0,
6.23	+/-0.030	(6:240	-		,	13
2.500	+/-0.010	2504	==			N.
0.37	+/-0.030	0.37"	ı			X
0.100	+/-0.010	0.102			9	
						- 1
						21 32
						- 9
8						14_JJF
						5
			76			

Measured by:	Jm	Audited by:	189	Prototype Approval:	N/A
Date: /L	4-03-1	Date:	14/3/3	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue P/O D3414-041	KJ/DD	
В	09.05.27	Dimensions updated per Dwg Rev B	KJ (A	
С	09.10.16	Dwg Rev updated to Rev C	KJ X	W



ITEM No. QTY. PART NUMBER DESCRIPTION D3414-041 LUG ASSEMBLY D3414-1 LUG BRACKET D3414-3 LUG

113173 MLJ 14-02-14



REV. DESIGN	DESCRIPTION DAPT AEPOSP		BY	DATE
A	NEW ISSUE			05.03.16
В	STANDARDS AND TI FLAT PATTERN FOR PREVENT FOULING REMOVED FROM -1	NIN SOLIDWORKS WITH CURRENT ANNSERED TO "B" SUZE BORDER. -1 INCREASED IN LENGTH TO AT INSTIT (SEE PARTI93), FLAT SPOTS, PART NOW "L" SKAPED) FOR EASE 87-3 ADDED TOLERANCE TO 3,230 445 1,20.	AJS	08.09.2
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)			09.06,17

DESIGN	QP.	HAWWESBURY, ONTARIO, CANADA		
DRAWN	CP			
CHECKED	1	DRAWING NO.	REV. C	
MFG. APPR.	En	D3414	SHEET 1 OF 3	
APPROVED	W.	TITLE	SCALE	
DE APPR.		LUG ASSEMBLY	NTS	
Mr. o Smith		CORPURATO SALE BY DART APPOARAGE AND		

DATE 09.06.17

D3414-041 LUG ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.52 lbs:

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